

Work Order ID 61123

Friday, August 06, 2010 2:19:32 PM



ASAP

Page 1

Item ID: D4148-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Fwd

Start Date: 8/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 2.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

MF

Date: 10-8-6

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: 8

Dwg Rev: 3

Deburr as required

10-8-9



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-8-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61123

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Page 2

Item ID: D4148-1

Accept

Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Start Date: 8/9/2010 Start Qty: 2.00

Required Date: 8/10/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(+2)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>Russ</u> Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

mf 10-8-9

10/08/09
DI 080 Aug mf
10-8-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 61123



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 8/9/2010

Required Date: 8/10/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	90.4082	0.3607	0.759368			



304/316 0.125 Sheet



B 10-8-4

Location

Loc Qty

Loc Code

MAT

90.4082

114488

0.6359

114799

89.7723

114799

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61123
Description: CROSSSTUB Lug PLATE FWD		Part Number: 4148-1
Inspection Dwg: D4148-1 Rev: B		Page 1 of 1

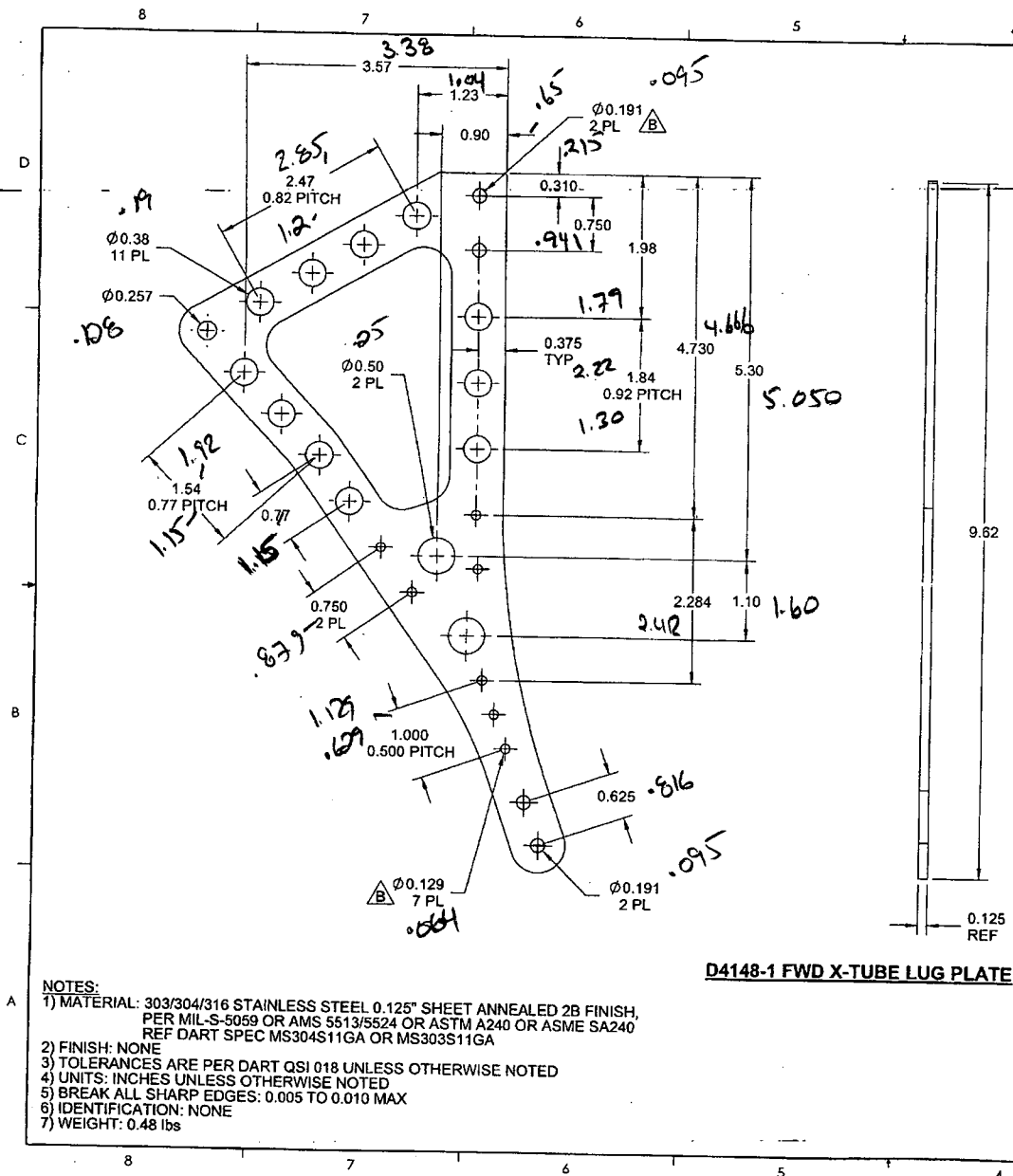
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✓		V ISO2	
Ø .257	+ .006 - .001	.259	✓		V	
Ø .191	+ .005 - .001	.193	✓		V	
Ø .138	+ .006 - .001	.139	✓		V	
2.47	TL .030	2.463	✓		V	
.82	TL .030	.821	✓		V	
3.57	TL .030	3.573	✓		V	
1.23	TL .030	1.232	✓		V	
.90	TL .030	.902	✓		V	
.310 3.10	TL .010	.313	✓		V	
.750	TL .010	.752	✓		V	
1.98	TL .030	1.981	✓		V	
1.84	TL .030	1.836	✓		V	
.92	TL .030	.917	✓		V	
.375	TL .010	.377	✓		V	
4.730	TL .010	4.733	✓		V	
5.30	TL .030	5.301	✓		V	
1.10	TL .030	1.107	✓		V	
2.284	TL .010	2.283	✓		V	
.625	TL .010	.629	✓		V	
1.000	TL .010	1.002	✓		V	
.500	TL .010	.501	✓		V	
.750	TL .010	.754	✓		V	

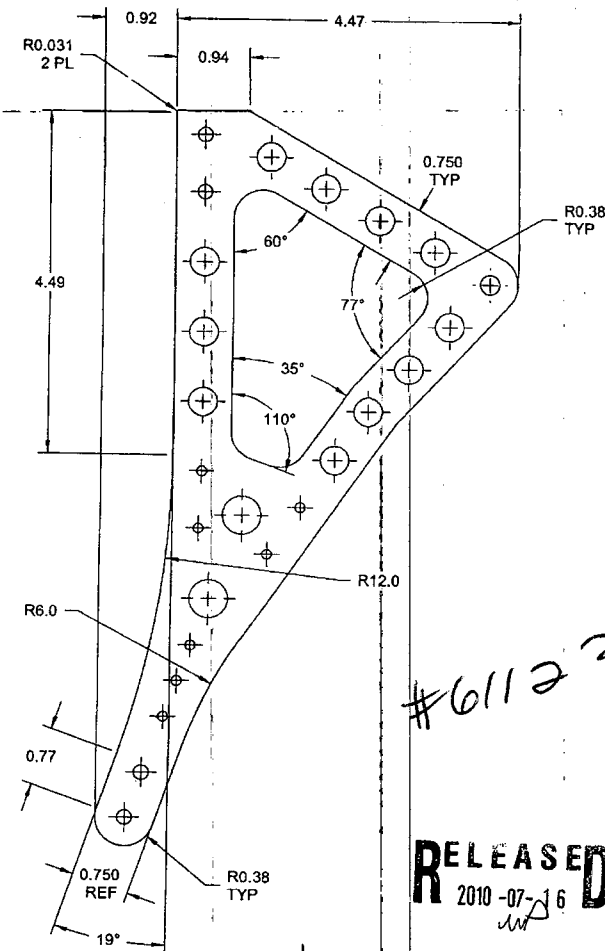
Measured by: IB	Audited by: S	Prototype Approval: N/A
Date: 10-8-9	Date: 10/08/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC MS304S11GA OR MS303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.48 lbs



RELEASED
2010-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.07.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR SOLEMEN AND REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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